DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-012466
Date Inspected: 03-Mar-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Chen Xi.

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Bay 1:

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of OBG component – Traveler Rail; weld joint 20TR1-019 – 003. Welder is identified as 219188. ZPMC Quality Control (QC) is identified as Yong Fu Zhi. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

FCAW of OBG component – Traveler Rail; weld joint 20TR1-035 – 003. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Liu Yang Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-1G.

CB 15:

During random inprocess inspection of this Cross Beam (CB), this QA Inspector observed ZPMC personnel performing repair welding of weld joint number CB202A-015-002. Welder was identified as 067611. Welding

process was identified as Shielded Metal Arc Welding (SMAW). WPS-345-SMAW-2G (2F)-Repair, was used as per Welding Repair Report (WRR) B-WR 9676 R-0. ZPMC Quality Control (QC) is identified as Xiang Feng. As per UT (Ultrasonic Testing) report (NO: B787-UT-10433) for this weld, thirteen (13) locations on this weld were identified for repair to be done.

Bay6: CB9.
This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

Outside Yard:

CB8, CB13, CB10, CB11, CB16, CB12 & CB14:
This QA Inspector observed that no significant work was being performed on the above mentioned CB's at the time when this QA was present.

Bay 15:

CB5:

During random inprocess inspection of this Cross Beam (CB), this QA Inspector observed ZPMC performing repair welding of weld no: CB202-005-016. Welder was identified as 062092. ZPMC QC identified as Mr. Li Yang & Mr. Weng Jian. This material is designated as Seismic Performance Critical Member (SPCM). Material thickness is 14mm. Welding process was identified as SMAW.
However, this QA Inspector observed that this repair welding is done without WRR. This QA informed ZPMC Quality Control (QC) identified as Mr. Weng Jian and American Bridge Fluor (ABF) QA identified as Mr. Weng Weng of this issue and that an incident report would be generated. Earlier in this day, ZPMC QC Mr. Weng Jian agreed to ensure the availability of WRR for this location to be welded.
For details, refer attached photos.

During random inprocess inspection of this Cross Beam (CB), this QA Inspector observed ZPMC personnel performing base metal repair welding of the areas from where temporary supports / fixtures were removed. This QA verified the WRR (No: B-WR10664 Rev-0) used for this welding / repair activity. Welder was identified as 062092. Welding process was identified as SMAW as per WPS: 345-SMAW-1G (1F)-FCM-Repair-1 & WPS: 345-SMAW-2G (2F)-FCM-Repair-1. ZPMC QC personnel was identified as Wang Jian.

CB6:
This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

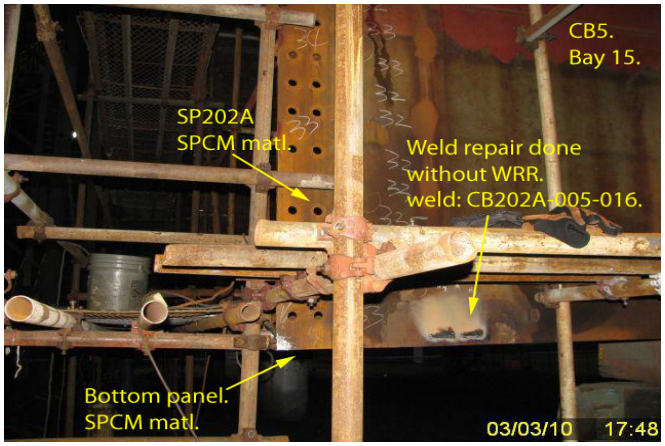
Trial Assembly:

CB7:
This QA Inspector observed that no significant work was being performed on this CB at the time when this QA was present.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer